

Work Order ID 56992

Tuesday, March 16, 2010 11:30:33 AM



Page 1

Item ID: D4034-043

Accept



Setup Start



Revision ID:

Item Name: Fwd Upper Rib Assembly

Stop



Start Date: 3/16/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 3/22/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-3-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4034	A

100 Weld per dwg A/R S.S. rod Batch: 1113328 0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564 ✓

2- Weld bushing in rib as per dwg ✓

SY 10/03/29 (5X)

110 QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

(5) 10.03.29

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

8 w 6/3/29

(XJ)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 56992

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Page 2

Item ID: D4034-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Upper Rib Assembly

Start Date: 3/16/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 3/22/2010 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location:

0.00



Packaging

Basket cell

Memo

0.00

Packaging

24 10/03/29 (5x)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/31 (5x)
10-3-31
(5)

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Picklist Print

Tuesday, March 16, 2010 11:30:32 AM

Page 1

Work Order ID: 56992

Parent Item: D4034-043

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 3/16/2010

Required Date: 3/22/2010

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4034-1 Rib		Manufactured	No			100	Each	0.0000	5.0000			
D4034-5 Rib		Manufactured	No			100	Each	0.0000	5.0000			
D2327-3 Spacer Bushing		Manufactured	No			100	Each	37.0000	5.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 13
44274 4
44365 9

Main Warehouse

WA 24
55167 4
55917 20

D4021-7 Manufactured No 100 Each 0.0000 5.0000



Hoop

B56996 → 5x

PD 10.03.24

BS 10/03/29

W/O:		WORK ORDER CHANGES					
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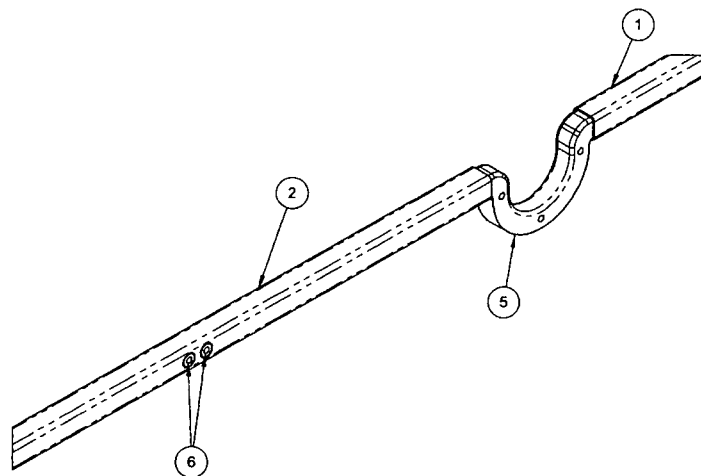
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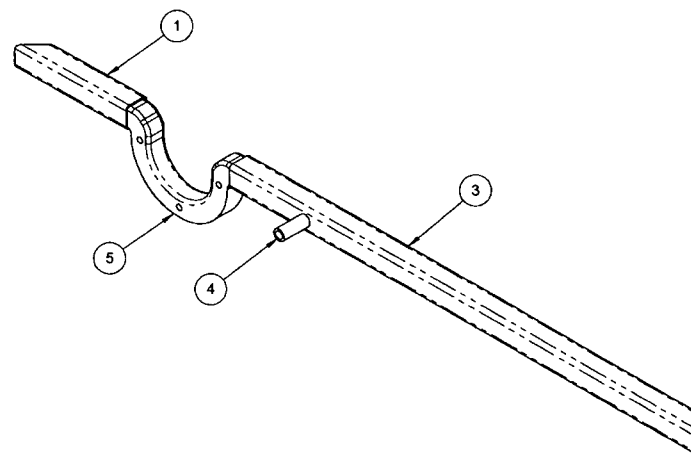
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	2		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

RELEASED
2010-03-12
MP

#56997

A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	JP		
MFG. APPR.	E		
APPROVED	MD		
DE APPR.	MD		
DATE	10.03.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4034

TITLE
UPPER RIB ASSY, BASKET BASE

REV. A
SHEET 1 OF 4

SCALE
NTS

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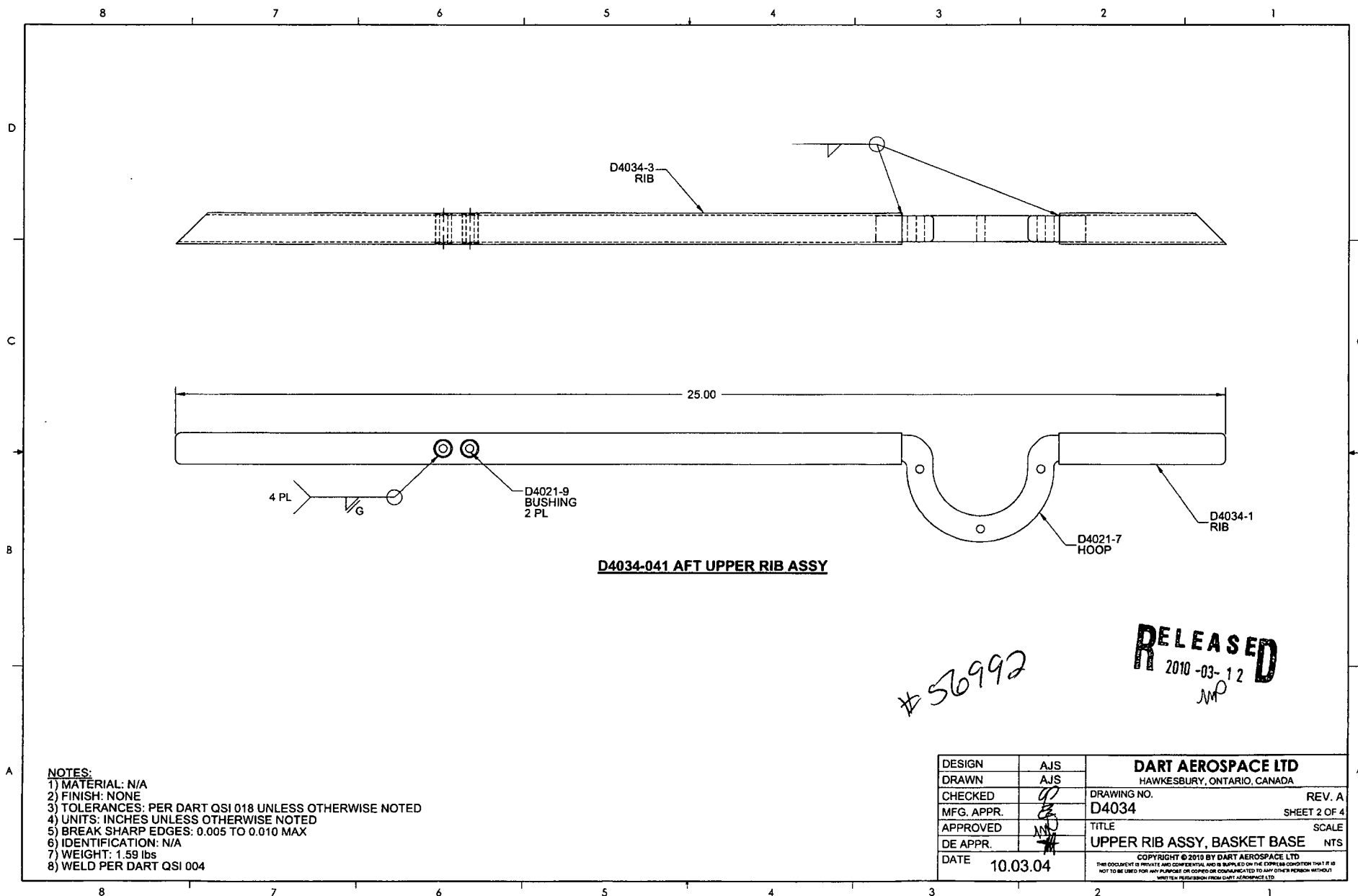
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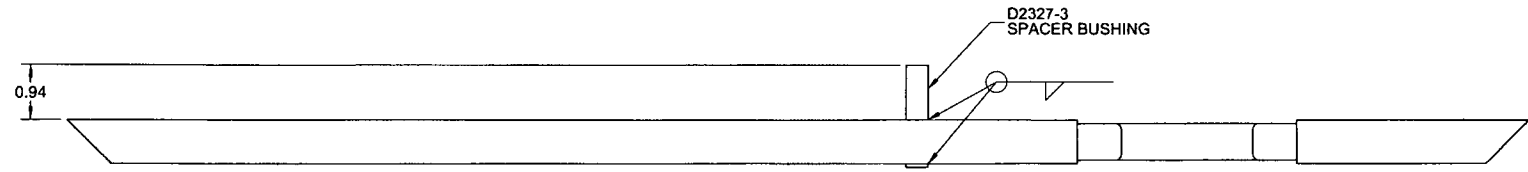
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8 7 6 5 4 3 2 1

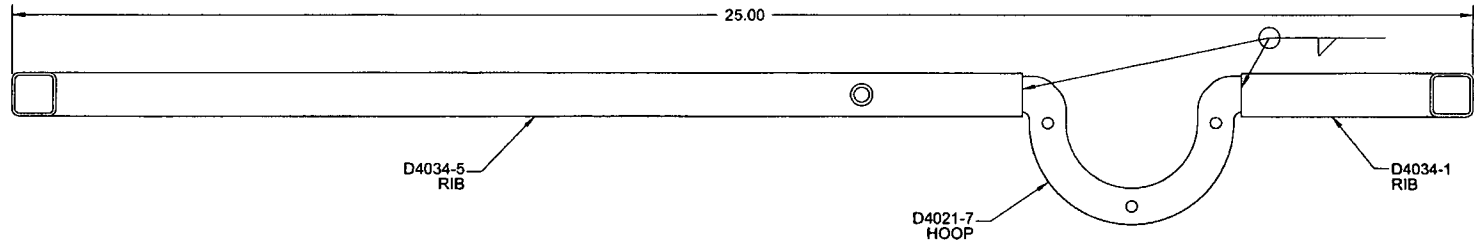
D

D



C

C



B

B

D4034-043 FWD UPPER RIB ASSY

#56992

RELEASED
2010-03-12
MP

A

A

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.58 lbs
 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	Q	DRAWING NO.	REV. A
MFG. APPR.	E	D4034	SHEET 3 OF 4
APPROVED	W	TITLE	SCALE
DE APPR.	W	UPPER RIB ASSY, BASKET BASE	NTS
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8 7 6 5 4 3 2 1

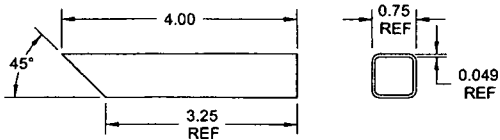
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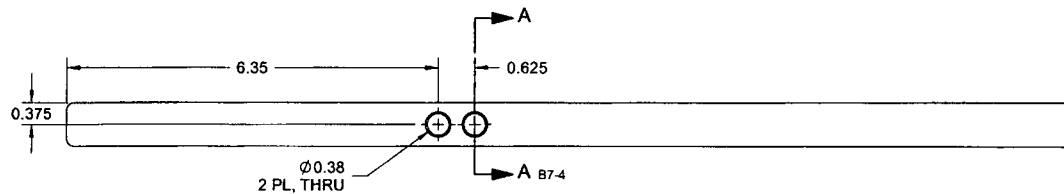


D4034-1 RIB

BREAK EDGE
0.030 X 45°
TYP



SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

56992

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 4 OF 4
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2010-03-12
[Signature]

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